

Work Order ID 128256

Tuesday, January 13, 2015 1:38:26 PM

128256

Page 1

Item ID: D4575-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Beam
 Start Date: 1/13/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-01-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4575	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
2024 .050	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

⑧

DL 15/02/12

⑧

DL 15/02/12

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Tuesday, January 13, 2015 1:38:26 PM

128256

Page 2

Item ID: D4575-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Beam

Stop

NS2

Start Date: 1/13/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(8)

DAS
38
9-89

FEB 13 2015

130

Bend as per dwg
NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3065

DAS
30
9-89

8

15/02/26

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(8)

DAS
38
9-89

FEB 27 2015

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Tuesday, January 13, 2015 1:38:26 PM

128256

Page 4

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 1503-11
ME
15-3-10

Picklist Print

Tuesday, January 13, 2015 1:38:29 PM

Page 1

Work Order ID: 128256

128256

Parent Item: D4575-1

D4575-1

Parent Item Name: Beam

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.01.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

24.0653

0.553

5

M2024T3S 050

2024-T3 .050 sheet

01/15/02/12

Location

Loc Qty

Loc Code

MAT022

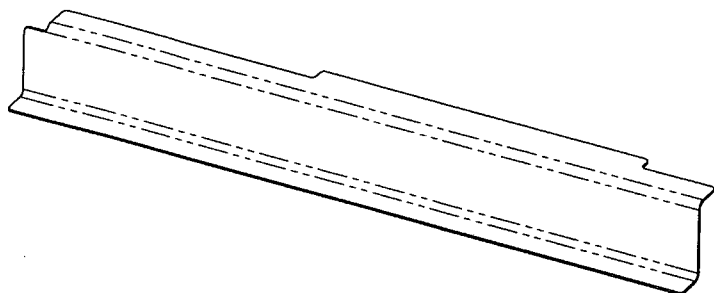
m128354

24.0653

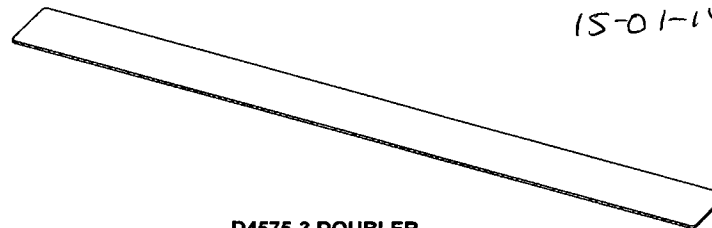
24.0653

5.1458

8 7 6 5 4 3 2 1



D4575-1 BEAM



D4575-3 DOUBLER

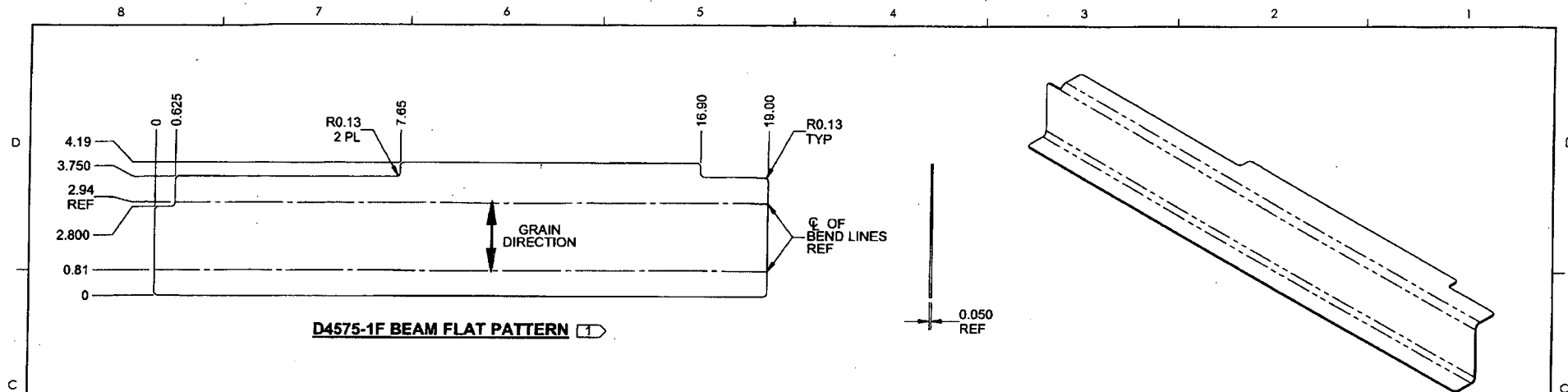
STAMP
REVISION
UNCO
SHEET

128256 MJS
15-01-14

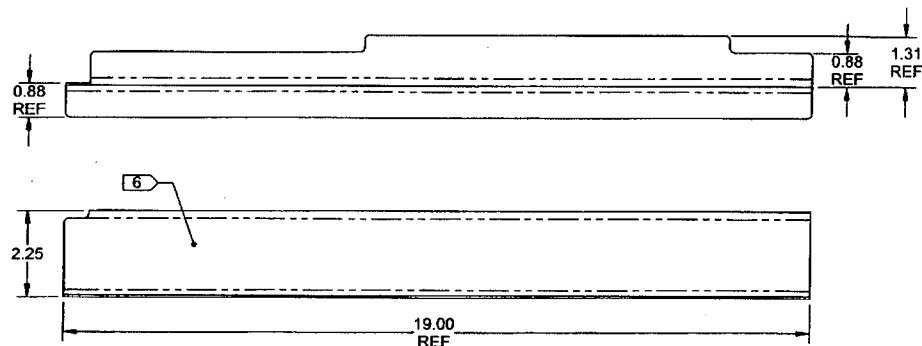
RELEASED
2012-01-12
MJD

A	NEW ISSUE	MB	12.01.05
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4575 TITLE REINFORCEMENT	REV. A	SHEET 1 OF 3
DRAWN		SCALE	NTS
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
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8 7 6 5 4 3 2 1



D4575-1F BEAM FLAT PATTERN 1



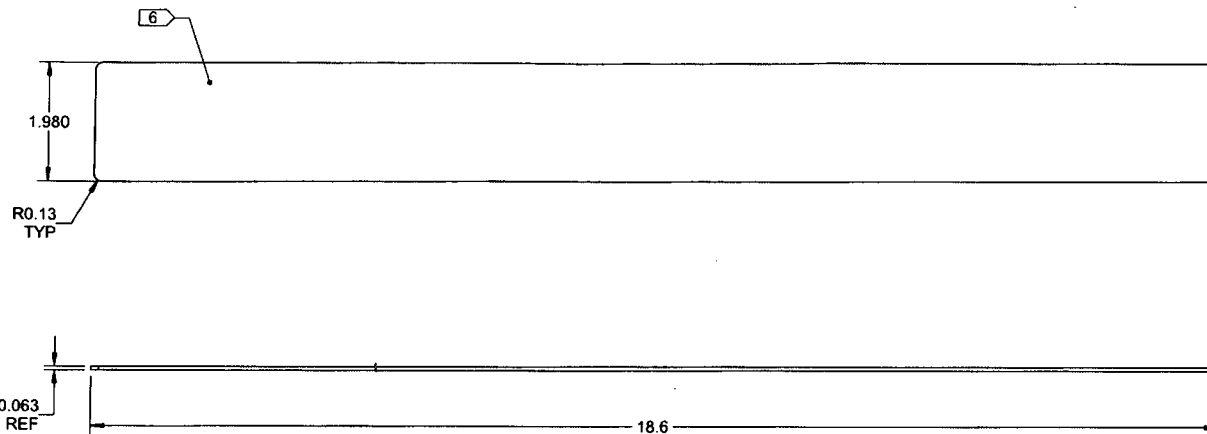
D4575-1 BEAM
(MAKE FROM D4575-1F)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4575-1" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.38 lbs

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D4575-3 DOUBLER

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2012-01-12

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4575-3" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.22 lbs

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